

13208

Dart Aerospace Ltd.

Date: Thursday, 17/04/2008 2:02:19 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HINGE BRACKET
Job Number :	38680		
Estimate Number :	10345		
P.O. Number :		Part Number :	D28571
This Issue :	17/04/2008	Drawing Number :	D2857 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	36855	Material :	
	Type : MACHINED PARTS	Due Date :	15/05/2008
Written By :		Qty:	24
Checked & Approved By :	<u>JD 08.4.17</u>	Um:	Each
Comment :	Est C 00.06.22 Removed P/O for powder coat EC Est D 06.05.01 Added level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
-----	--------------------	--------------------------



Comment: Qty: 0.4594 f(s)/Unit Total: 11.0250 f(s)
 Material: 2.00" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B200001250)
 Batch M105225

SD 08/06/26

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks 5.2"

SD 08/06/26

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2857-1

M.A./SD 08/06/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A./SD 08/06/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 2:02:19 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 38680

Part Number: D28571

Job Number:



Sq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

28/07/03

(24)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

N/A

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

BR

08-07-07

(24)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/07 x24

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M107925

9H

08-07-08

(x24)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

08/07/08

(24)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5750

AS

08/07/08

(24)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/09

Job Completion



ME

08-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38680
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

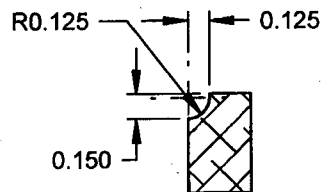
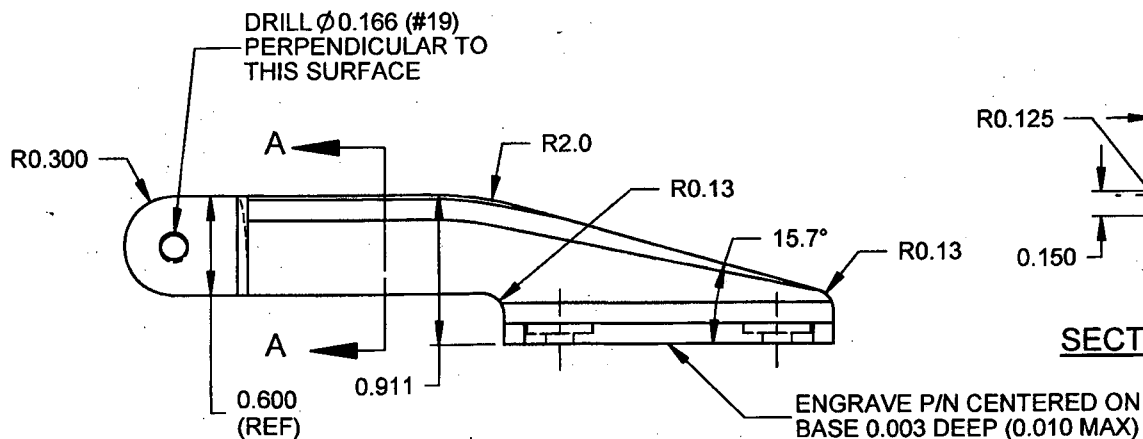
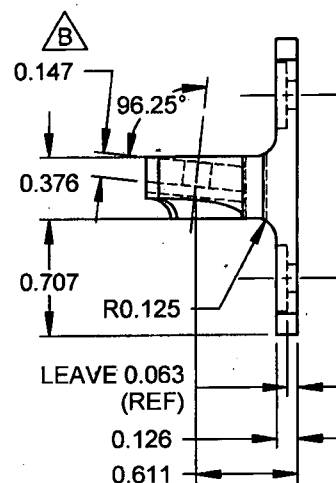
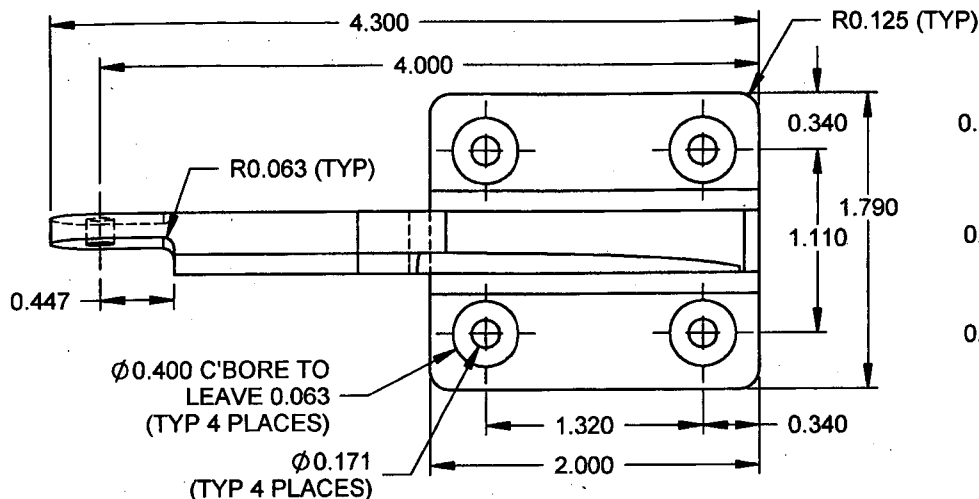
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.3088	✓			
4.000	+/-0.010	4.0045	✓			
0.340	+/-0.010	0.344	✓			
1.110	+/-0.005	1.106	✓			
1.790	+/-0.010	1.791	✓			
1.320	+/-0.005	1.323	✓			
2.000	+/-0.010	2.003	✓			
0.340	+/-0.010	0.340	✓			
0.447	+/-0.010	0.441	✓			
Ø0.171	+0.005/-0.000	Ø0.173	✓			
0.147	+/-0.010	0.146	✓			
0.376	+/-0.010	0.376	✓			
0.126	+/-0.010	0.123	✓			
0.063	+/-0.010	0.062	✓			
Ø0.166	+0.005/-0.000	Ø0.168	✓			
0.911	+/-0.010	0.911	✓			
0.600	+/-0.010	0.606	✓			
0.125	+/-0.010	0.126	✓			
0.150	+/-0.010	0.147	✓			

Measured by: H.A. FMA	Audited by: DJP	Prototype Approval:	N/A
Date: 08/06/27	Date: 08/07/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

DART

DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET	SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

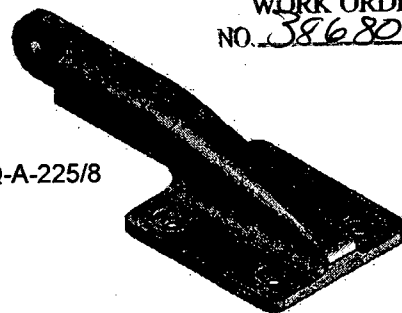
RELEASED
06-10-13

SHOP COPY
SECTION A-A RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38680

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



COPYRIGHT © 1998 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.